

Date: Tuesday, 13/05/2008 2:23:10 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARSHOE |
| Job Number | : 39251 | | |
| Estimate Number | : 13310 | | |
| P.O. Number | : | Part Number | : D37931 |
| This Issue | : 13/05/2008 S.O. No. : | Drawing Number | : PRELIM |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : R & D SM/MED FAB | Drawing Revision | : PRELIM |
| Previous Run | : | Material | : |
| Written By | : | Due Date | : 20/05/2008 Qty: 2 Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est Rev:A 08-05-13 new issue DD verified by: | | |



Additional Product

Job Number:



PRELIMINARY ISSUE

| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
| | | |
| Comment: Qty.: 0.5733 sf(s)/Unit Total : 1.1466 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <u>107909</u> <u>IB 8-5-14</u> | | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3793 Dwg Rev: <u>PRE.L</u> <u>IB 8-5-14</u> Prog Rev: <u>PRE.L</u> 2-Deburr if necessary <u>IB 8-5-14</u> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-5-14</u> | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK <u>080514</u> <u>2</u> | | |
| 5.0 | BRAKE NC | NC BRAKE |
| | | |
| Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs <u>080514</u> <u>2</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 2:23:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39251

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

PA 06-05-14

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A

PA 08-05-16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE RECALL



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eng's job

EFFECTIVE 08-05-21 AUTH LL

RELEASED PA DATE 08-05-15

NOT FOR STOCK PA 08-05-21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16 JF

Job Completion



MF 08-05-15

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

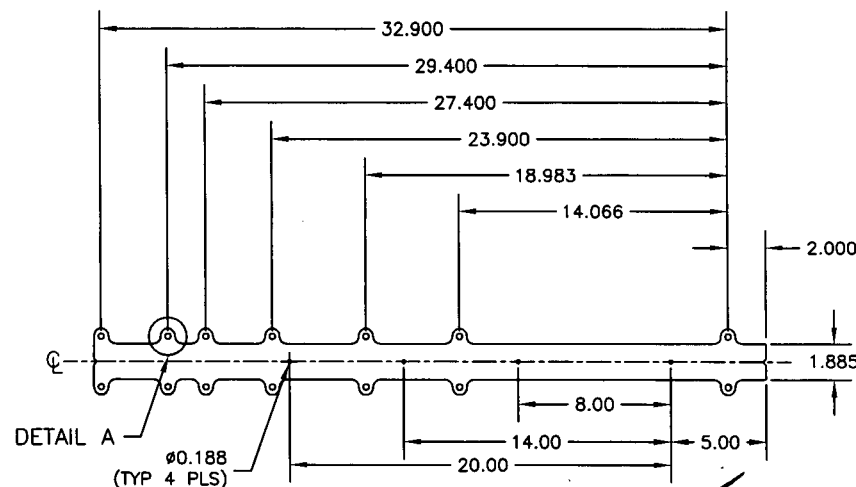
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

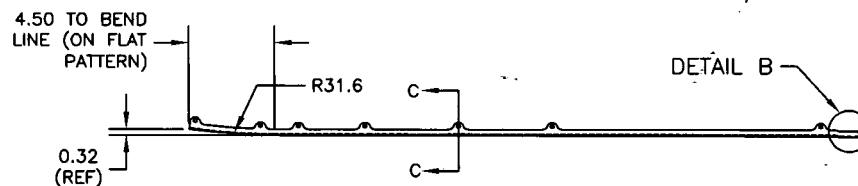
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | | |
|---------|-----------|-------------|-----------|--------------------------|
| DESIGN | <i>PH</i> | DRAWN BY | <i>PH</i> | DART AEROSPACE USA, INC. |
| CHECKED | | APPROVED | | PORT HADLOCK, WA |
| DATE | 08.05.13 | DRAWING NO. | D3793 | REV. A |
| | | TITLE | WEARSHOE | SHEET 1 OF 3 |
| A | 08.05.13 | NEW ISSUE | | SCALE NTS |



D3793-1 FLAT PATTERN



D3793-1 BEND DETAIL

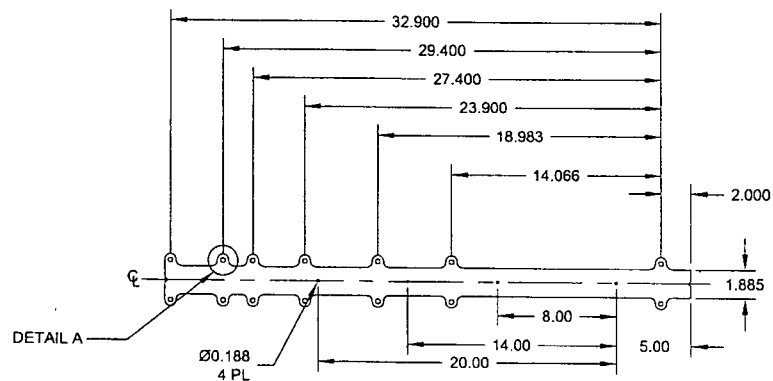
*REDO
dx*

NOTES

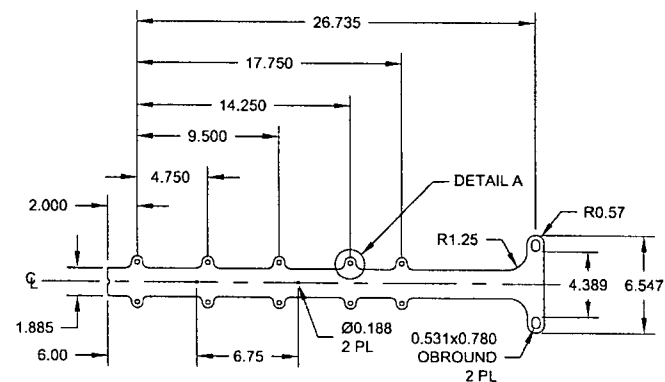
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) SEE PAGE 3 FOR DETAILS AND SECTION

W 08/25/13

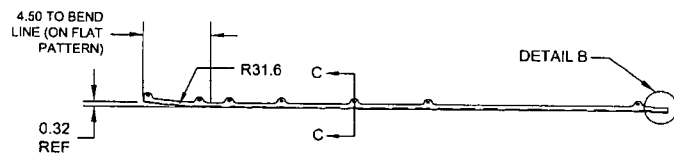
PRELIMINARY ISSUE
PH 07.05.13



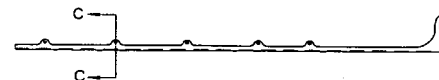
D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

| | | | | | | | | |
|--|--|-------------|--|---|----|--------------|------|--|
| A | | NEW ISSUE | | PH | | 08.05.14 | | |
| REV. | | DESCRIPTION | | | BY | | DATE | |
| DESIGN | | PH | | DART AEROSPACE USA, INC | | | | |
| DRAWN | | PH | | PORT HADLOCK, WA | | | | |
| CHECKED | | | | DRAWING NO. | | REV. A | | |
| MFG. APPR. | | PH | | D3793 | | SHEET 1 OF 2 | | |
| APPROVED | | PH | | TITLE | | SCALE | | |
| DE APPR. | | PH | | WEARSHOE | | NT | | |
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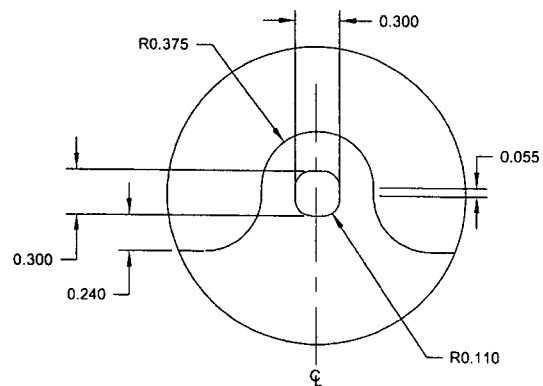
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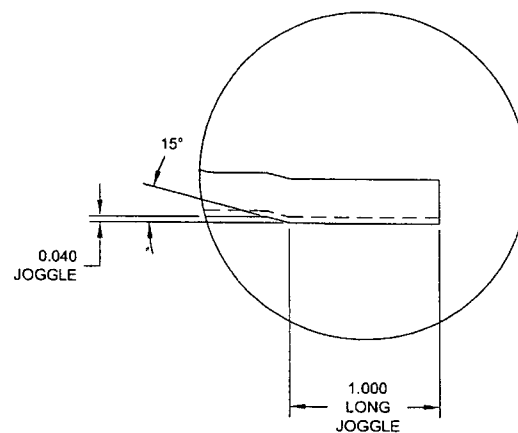
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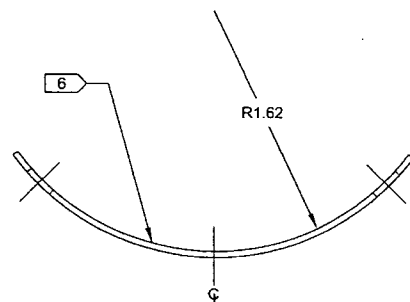
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DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-14

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | DS | D3793 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARSHOE | NTS |
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